

Work Order ID 127415

127415

Page 1

Item ID: D2484

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Locknut

Stop *NS2*

Start Date: 12/17/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-12-22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2484	Rev A
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100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 26935 Order per Dwg D2484 Material release note required

noe master P/N: 91343 A100

CX 15/01/06 80

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

50x SP15-01-8

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(56) DAS
38
9-89

JAN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127415

December-17-14 1:23:12 PM

127415

Page 2

Item ID: D2484

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Locknut

Stop

NS2

Start Date: 12/17/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ~~51007~~

0.00

130

Packaging

Memo

0.00

Packaging

SO

CA 15-01-08

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ

15-01-09

15-1-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:23:12 PM

Page 1

Work Order ID: 127415

127415

Parent Item: D2484

D2484

Parent Item Name: Locknut

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A00.03.02New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2484P		Purchased	No			110	Each	0.0000	1	10			
D2484P									**				
Lock Nut													

50x 801501-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling									
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Process									
Supplier									
Training									
Transport									
Unapproved									

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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B W	APPROVED <i>[Signature]</i>	DRAWING NO. D2484	REV. A SHEET 1 OF 1
DATE 95:10:06		TITLE LOCK NUT	SCALE

SPECIFICATION CONTROL DRAWING



1/4-20 LOW PROFILE
NYLON LOCK NUT



OR

1/4-20 SERATED FLANGE
LOCK NUT



14-12-22
NO. 1274/5 M-5
WITHOUT NOTICE
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26935

Purchase Order Date 1/6/2015

PO Print Date 1/6/2015

Page Number 3 of 5

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$2.24

7	63215K34	Bearing	1/8/2015	20.00		
			Yes	Each	\$17.24	\$344.80

AS PER DWG D2611 REV. C
B127926

Line Total: \$344.80

8	92311A599	SET SCREW	1/8/2015	250.00		
			Yes	Each	\$0.22	\$54.00

AS PER DWG D2712 REV. B
B127910

Line Total: \$54.00

9	D2484P	Lock Nut	1/8/2015	50.00		
			Yes	Each	\$0.38	\$19.15

AS PER DWG D2484 REV. A
B127415

MCMaster P/N: 91343A100

Note:

1/6/2015

SP1501-8

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO26935

Order Placed By
Chantal Lavoie

McMaster-Carr Number
5509849-01

Page 1 of 1

01/06/20

Line	Product	Ordered	Shipped
1	1761K22 Galvanized Steel Clamp, 4 Trade Size for, Quick-Assembly Duct Your Part Number: 71400-20	2 Each	2 ✓
2	1761K23 Galvanized Steel Clamp, 5 Trade Size for, Quick-Assembly Duct Your Part Number: 71400-20	8 Each	8 ✓
3	1317T18 Incandescent Light Bulb, Intermediate-Base, Globe Shape No. S11, 40 Watt, Packs of 1 Your Part Number: 71400-35	2 Packs	2
4	9776K33 1" W X 75" L Hook, Adhesive Back, Beige, Lengths of 75 Your Part Number: B127766	1 Length	1
5	7130K41 Nylon Cable Tie, 6" LG, 1-1/2" Bundle Diameter, 10 lb Break Strength, White, Packs of 100 Your Part Number: B127375	1 Pack	1 ✓
6	91249A146 Black-Oxide Finish Pan Head Phillips Machine Screw, 18-8 Stainless Steel, 6-32 Thread, 3/8" Length, Packs of 100 Your Part Number: B127703	1 Pack	1
7	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Your Part Number: B127926	20 Each	20
8	92311A599 18-8 Stainless Steel Cup Point Set Screw, 5/16"-24 Thread, 5/8" Long, Packs of 50 Your Part Number: B127910	5 Packs	5 ✓
9	91343A100 Type 316 Stainless Steel Serrated-Flange Hex Locknut, 1/4"-20 Thread Size, 7/16" W, 15/64" Overall Height, Packs of 10 Your Part Number: D2484P	5 Packs	5 ✓
10	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Your Part Number: B127488	40 Each	40
11	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10 Your Part Number: B127549	5 Packs	5
12	2939A28 High-Speed Steel Extended-Reach Drill Bit, Uncoated, 3/8", 12" Overall Length, 8.3" Drill Depth Your Part Number: 71500-90	1 Each	1 ✓

8015-01-8